

Work Order ID 66462

Tuesday, February 15, 2011 11:08:32 AM



Page 1

Item ID:	D4014-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Guage Cover				Stop	
Start Date:	2/16/2011	Start Qty:	8.00			
Required Date:	3/2/2011	Req'd Qty:	8.00			
Reference:						

Approvals:	Process Plan:	<u>UNF</u>	Date:	<u>11-02-15</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4014	A								

100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet									
<u>6061 .053</u>									
	Memo								
	1-Cut as per Dwg								
	Dwg Rev: <u>R</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								

110		0.00							
QC		0.00							
Quality Control									
	Memo								
	QC2- Inspect parts off machine FAI/FAIB								

B11-2-15

9

B11-2-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4014-3

Accept

Revision ID:

Item Name: Guage Cover

Start Date: 2/16/2011 Start Qty: 8.00

Required Date: 3/2/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/11/02/16



130



Small Fab

Small Fab

Memo

form as per dwg using DT9589

0.00

0.00

8/11/02/17 9

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/02/17



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Page 4

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Revision ID:

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Required Date: 3/2/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/2/24 (925)

11/02/24

mf
11-02-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, February 15, 2011 11:08:28 AM

Page 1

Work Order ID: 66462

Parent Item: D4014-3

Parent Item Name: Guage Cover




Start Date: 2/16/2011

Required Date: 3/2/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 10.01.28 new issue Prelim EC verified by: DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	162.0000	0.007	0.058947			
													
6061-T6 .063 Sheet													



B11-2-16

Location

Loc Qty

Loc Code

MAT

127.6

116308

35.6

116623

92

MAT21

34.4

113608

34.4

113608

9

W/O:		WORK ORDER CHANGES					
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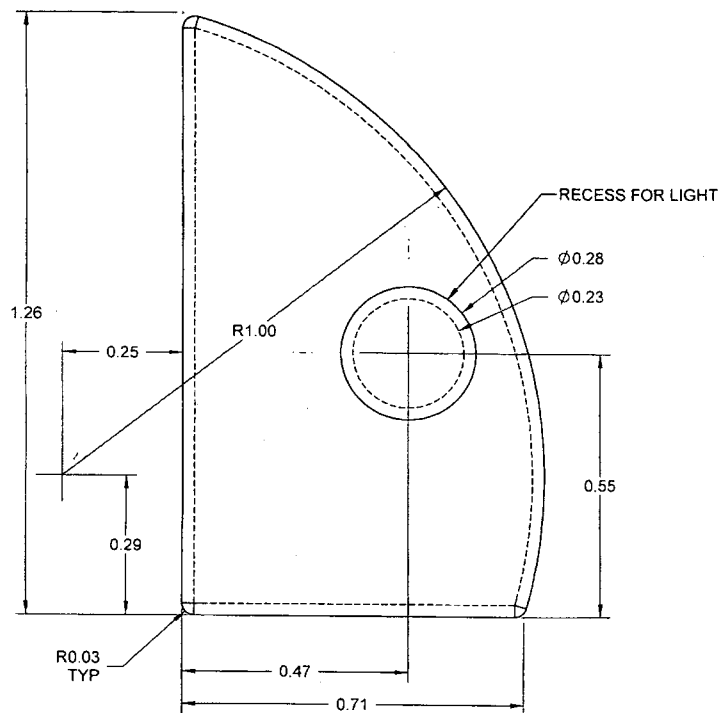
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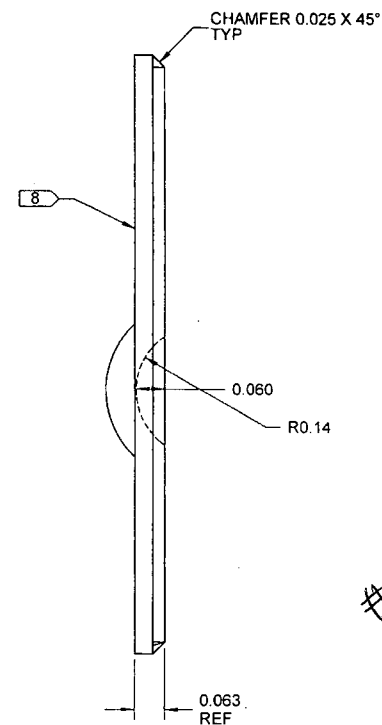
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4014-3	JCA-M47-2-31



D4014-3 GAUGE COVER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs
- 8) POWDER COAT THIS SIDE ONLY



#66462

RELEASED
2010-05-05
MD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4014	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE COVER	SCALE
DE APPR.			NTS
DATE	10.03.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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